

Date: Tuesday, 07/04/2009 10:18:29 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b> : 46955	
<b>Estimate Number</b> : 10534	
<b>P.O. Number</b> :	<b>Part Number</b> : D2574
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2574 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 45924	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/04/2009 <b>Qty</b> : 10 <b>Um</b> : Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.04.07</u>	
<b>Comment</b> : Est Rev: I As Per RevE 06-01-27 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101005	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2574  
 Ensure that grain is along 5.00" length  
 Batch No: 46411

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 46955 Double check by: mmf

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

PTO

J.L. / mmf = 09/04/18

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

J.L. / mmf = 09/04/18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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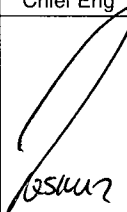

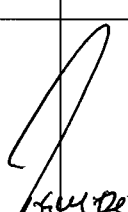

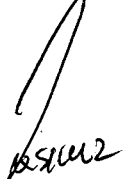
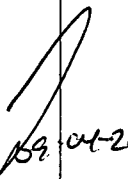


**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L. / mmf = 09/04/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2574 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/04/02  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46955</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/15	2.0	-1 part inside chamber of .06 is .095 R.C. chamber tool has the same offset for two different operations, offset was set for one operation but was too deep for 2nd operation *need different offsets for all operations		<del>Acceptable</del> Acceptable see NCR on next page. Same part: same NCR.	JL 09/04/15	SP 09/04/20		
								

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:29 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 46955

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

85 09/04/20 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

09-04-20

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

HL 09-04-20

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Sorted/20 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5434

A 09/04/21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



MF 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.16	2	CHAMFER ON BASE OF FLANGES IS 0.055" INSTEAD OF 0.063". ON (1) PART.	CP 09.04.16 pc QSI 042	Acceptable	SP 09/04/20	09.04.20	CP 09.04.16 pc QSI 042	09.04.20

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46955
<b>Description:</b> Saddle, Aft Inboard		<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.438	.438	.440		
B	1.745	1.755		1.750	1.746	1.746	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.748	1.746	1.748		
E	7.990	8.010		7.999	8.003	8.003	8.003		
F	0.490	0.510		.499	.501	.498	.491		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.504	.502	.498	.502		
J	1.174	1.184		1.179	1.177	1.177	1.177		
K	0.558	0.578		.571	.564	.565	.566		
L	1.174	1.184		1.179	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.368	1.370	1.370		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.124	4.123	4.124	4.124		
P	0.115	0.135		.124	.126	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.252	.254	.254		
S	0.115	0.135		.126	.126	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.225	3.226	3.227		
V	0.230	0.250		.238	.240	.240	.240		
W	0.115	0.135		.128	.128	.129	.133		
X	0.307	0.312		.310	.310	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.361	.363	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.626	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.248	.251	.253		
AE	1.500	1.520		1.515	1.515	1.515	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.280	.270	.280		
AH	0.240	0.260		.247	.249	.249	.250		
AI	2.000	2.020		2.005	2.005	2.005	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	09/04/14

Audited by:	RF
Date:	09/04/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 46955
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 5	2 6	3 7	4 8	By	Date
A	0.438	0.443		.438	.438	.439	.440		
B	1.745	1.755		1.748	1.748	1.748	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.747	1.748	1.750		
E	7.990	8.010		8.003	8.003	8.005	8.001		
F	0.490	0.510		.510	.505	.490	.499		
G	0.257	0.262		.258	.258	.258	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.500	.501	.501		
J	1.174	1.184		1.178	1.179	1.178	1.178		
K	0.558	0.578		.571	.569	.569	.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.122	4.124	4.125		
P	0.115	0.135		.125	.124	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.253	.254		
S	0.115	0.135		.121	.129	.131	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.225	3.225	3.228	3.226		
V	0.230	0.250		.238	.239	.241	.240		
W	0.115	0.135		.124	.127	.127	.126		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.363	.360	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.625	.625	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.514	1.516	1.517	1.516		
AF	0.115	0.135		.125	.135	.116	.135		
AG	0.240	0.280		.280	.280	.280	.276		
AH	0.240	0.260		.247	.246	.245	.249		
AI	2.000	2.020		2.001	2.000	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J.L
Date:	09/04/18

Audited by:	J.P.
Date:	09/24/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 46955
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.998	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.258	.259				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.503	.503				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		.569	.572				
L	1.174	1.184		1.178	1.179				
M	1.365	1.375		1.369	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.124				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.253	.251				
S	0.115	0.135		.127	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.226	3.230				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.126	.127				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.508	.500				
AB	0.615	0.635		.627	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.245				
AE	1.500	1.520		1.517	1.516				
AF	0.115	0.135		.120	.135				
AG	0.240	0.280		.280	.260				
AH	0.240	0.260		.249	.246				
AI	2.000	2.020		2.004	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	JL
Date:	09/04/18

Audited by:	SP
Date:	09/04/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

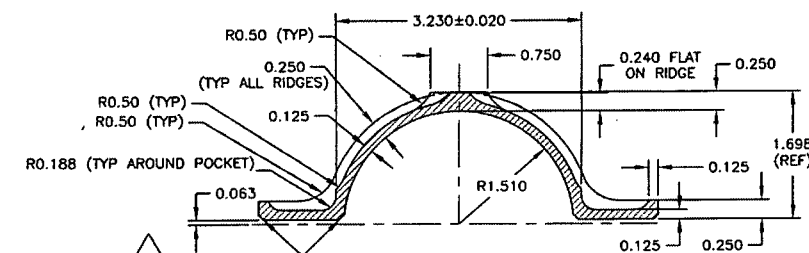
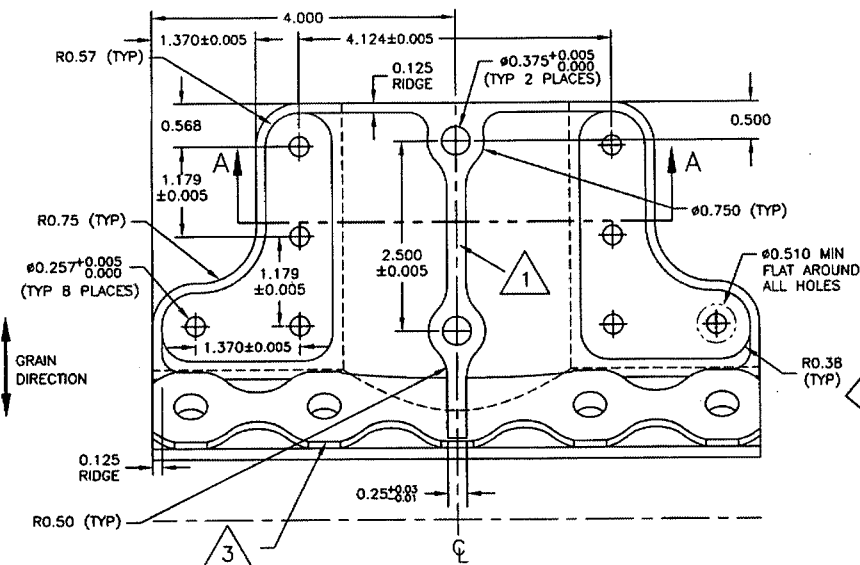
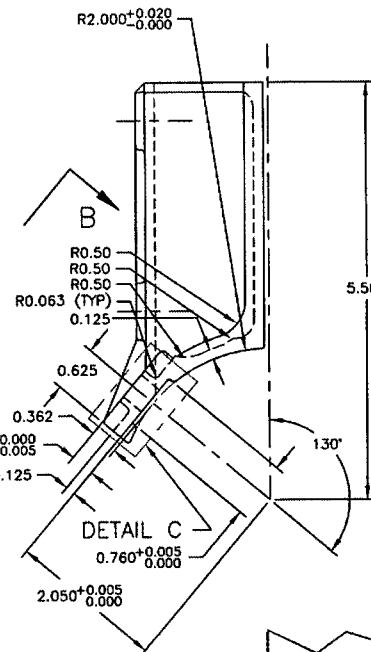
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05.12.06

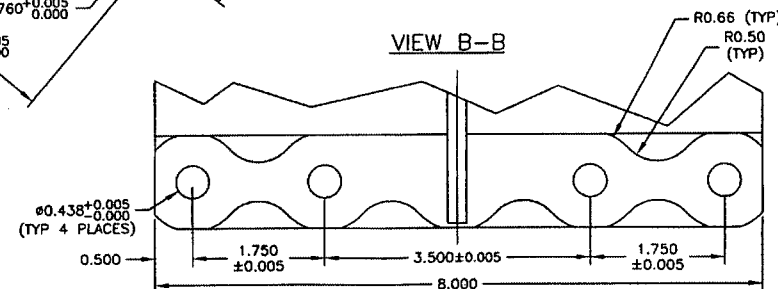
# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A



VIEW B-B

DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	APPROVED	DART
DATE	05.07.13	DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
DRAWING NO.	D2574	REV. E
TITLE	INNER AFT SADDLE	SHEET 1 OF 1
SCALE	2:3	

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